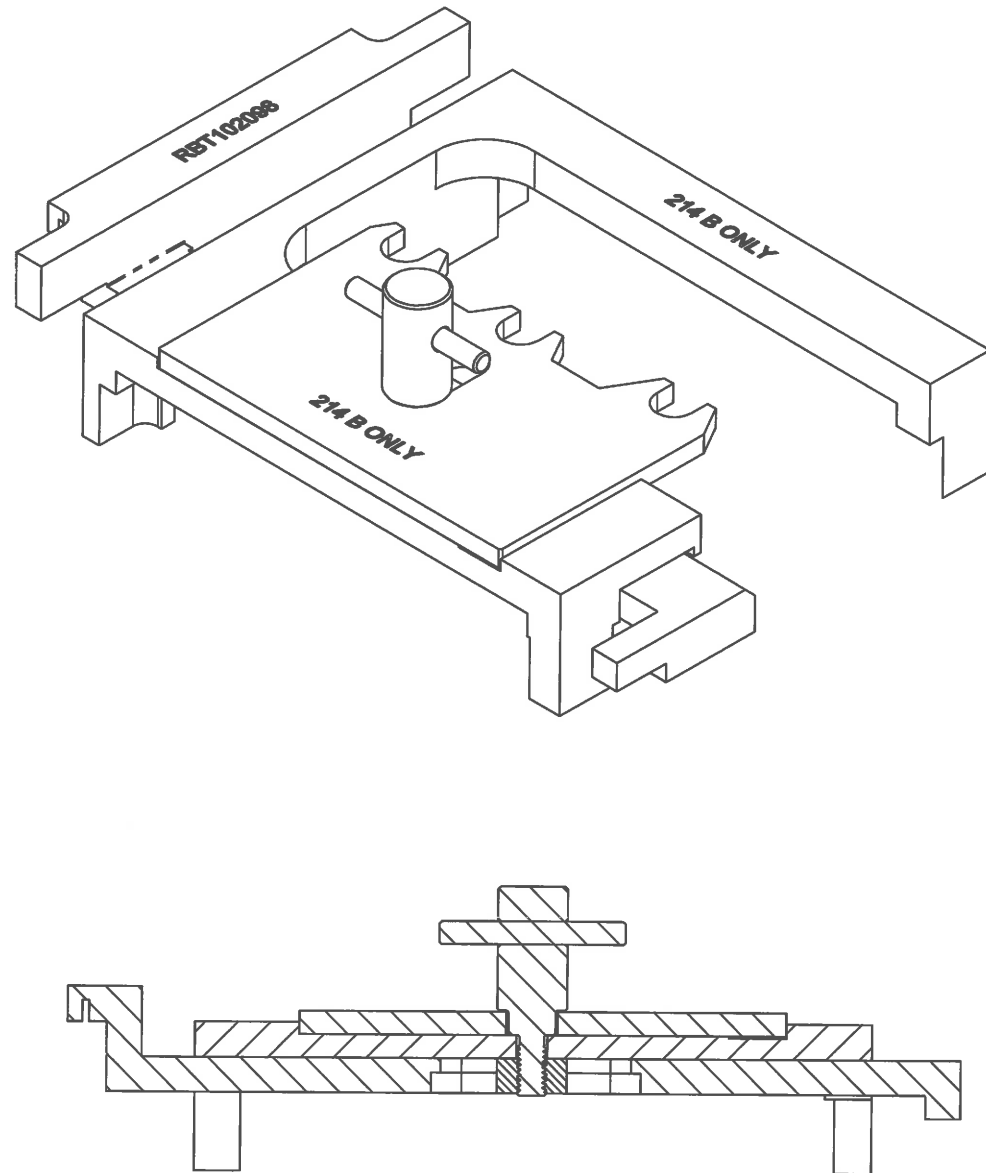
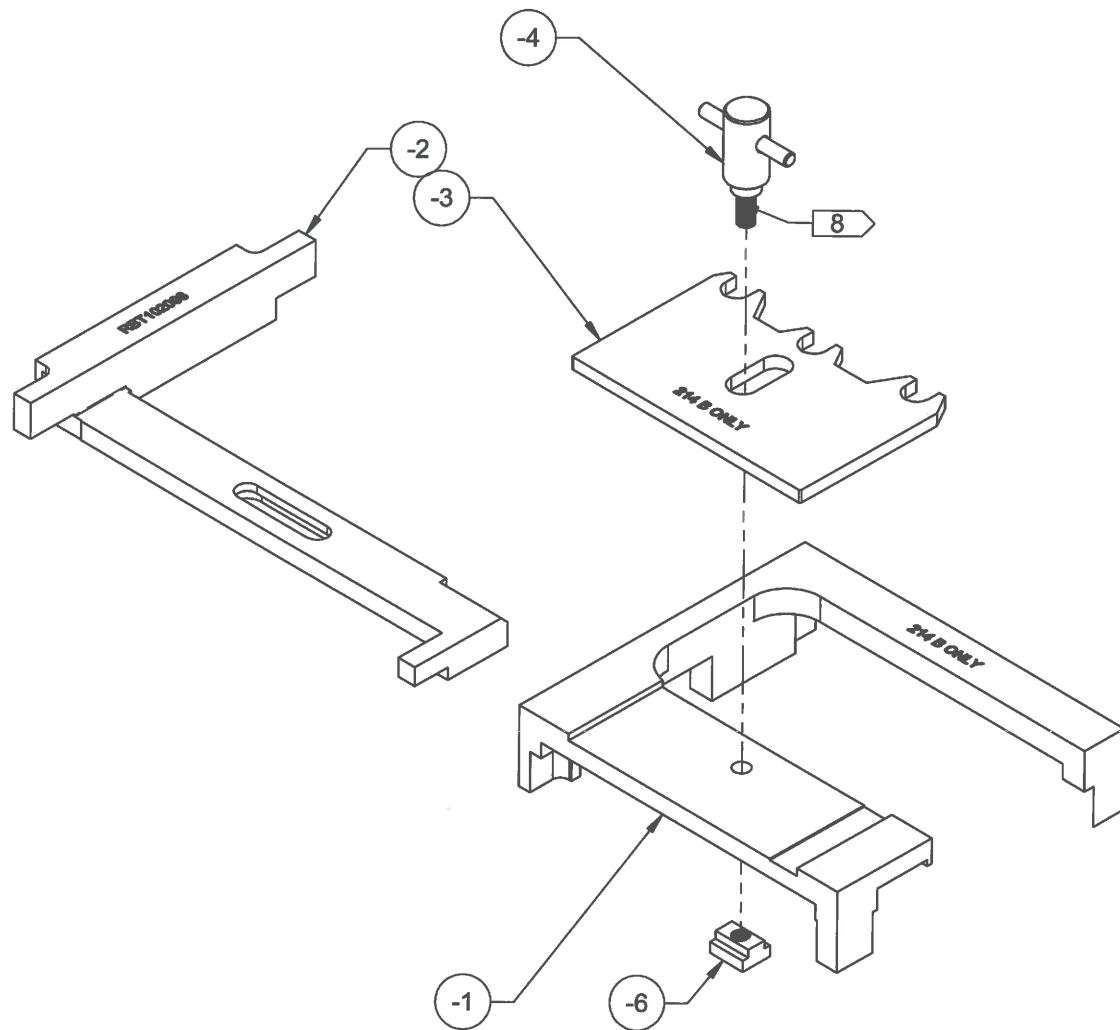


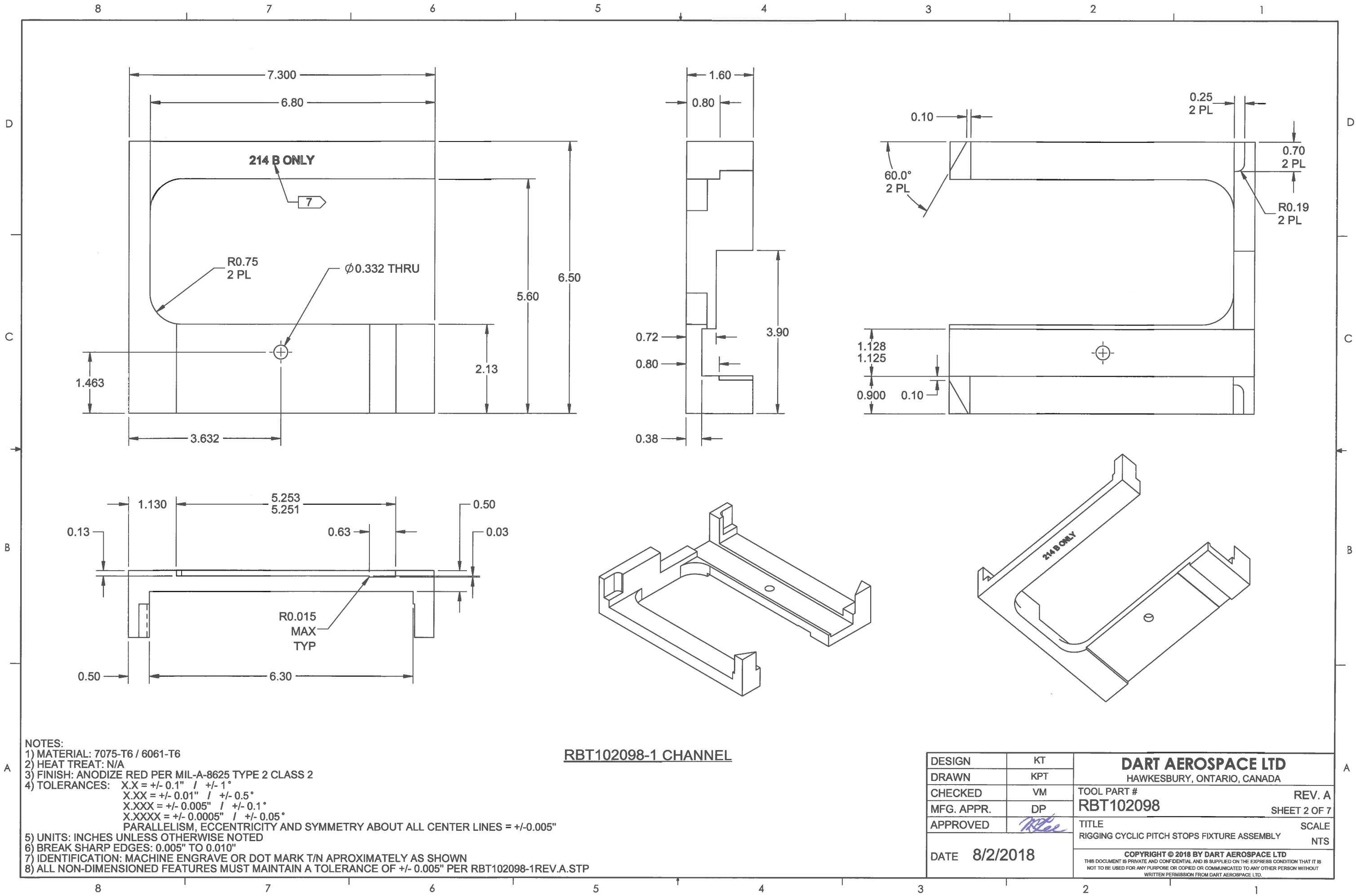
ITEM #	QTY	PART #	PART TITLE
-1	1	RBT102098-1	CHANNEL
-2	1	RBT102098-2	SQUARE CHANNEL
-3	1	RBT102098-3	PLATE
-4	1	RBT102098-4	SCREW ASSY
-6	1	RBT102098-6	T-SLOT NUT



### RBT102098 RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY


NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: N/A  
7) IDENTIFICATION: N/A  
8) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -4 THEN ASSEMBLE WITH ITEM -6, HAND TIGHT

A	NEW ISSUE	18-780	KT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RBT102098	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 8/2/2018		RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY	NTS
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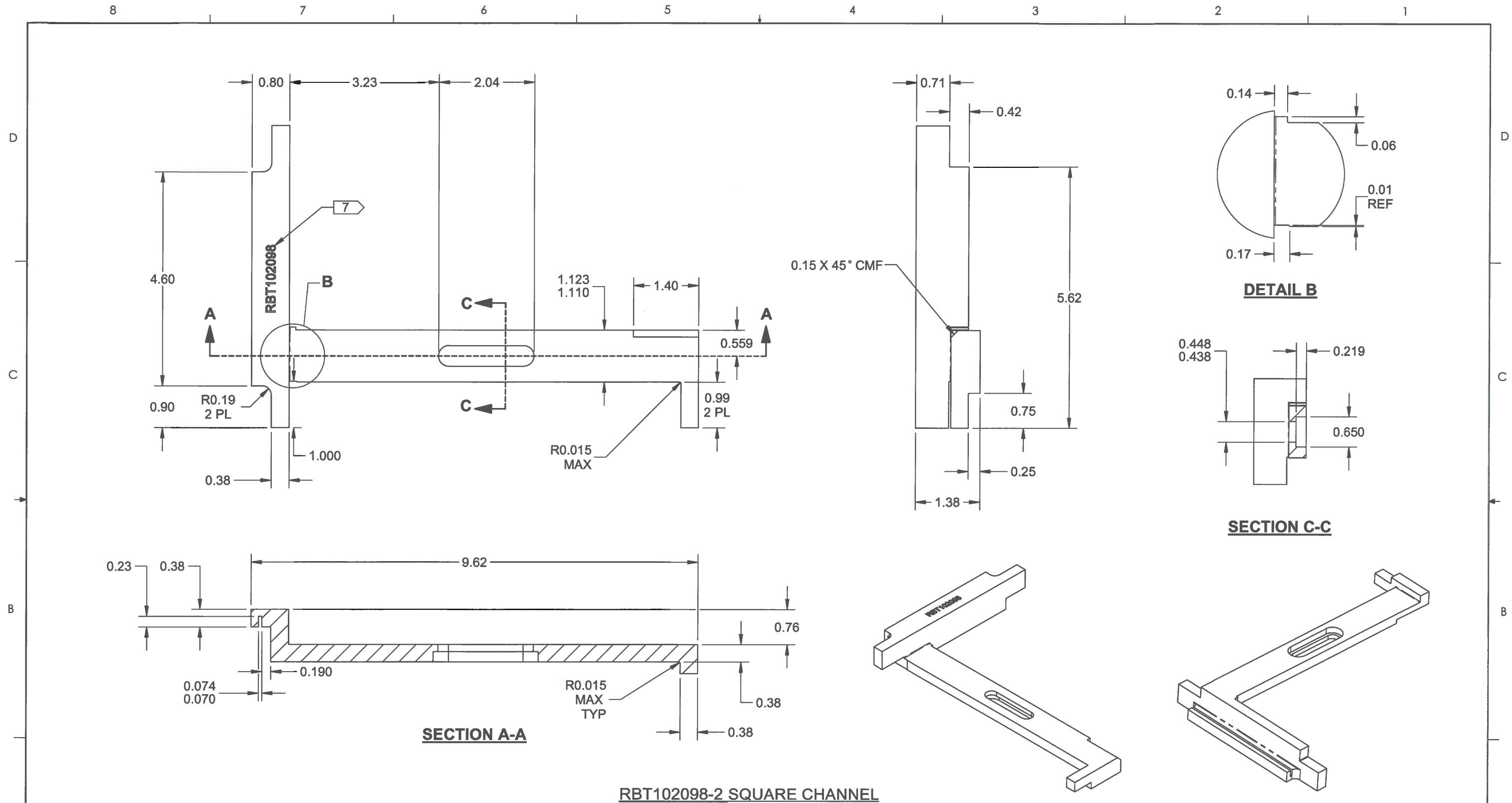


NOTES:  
1) MATERIAL: 7075-T6 / 6061-T6  
2) HEAT TREAT: N/A  
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: 0.005" TO 0.010"  
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N APROXIMATELY AS SHOWN  
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER RBT102098-1REV.A.STP

RBT102098-1 CHANNEL

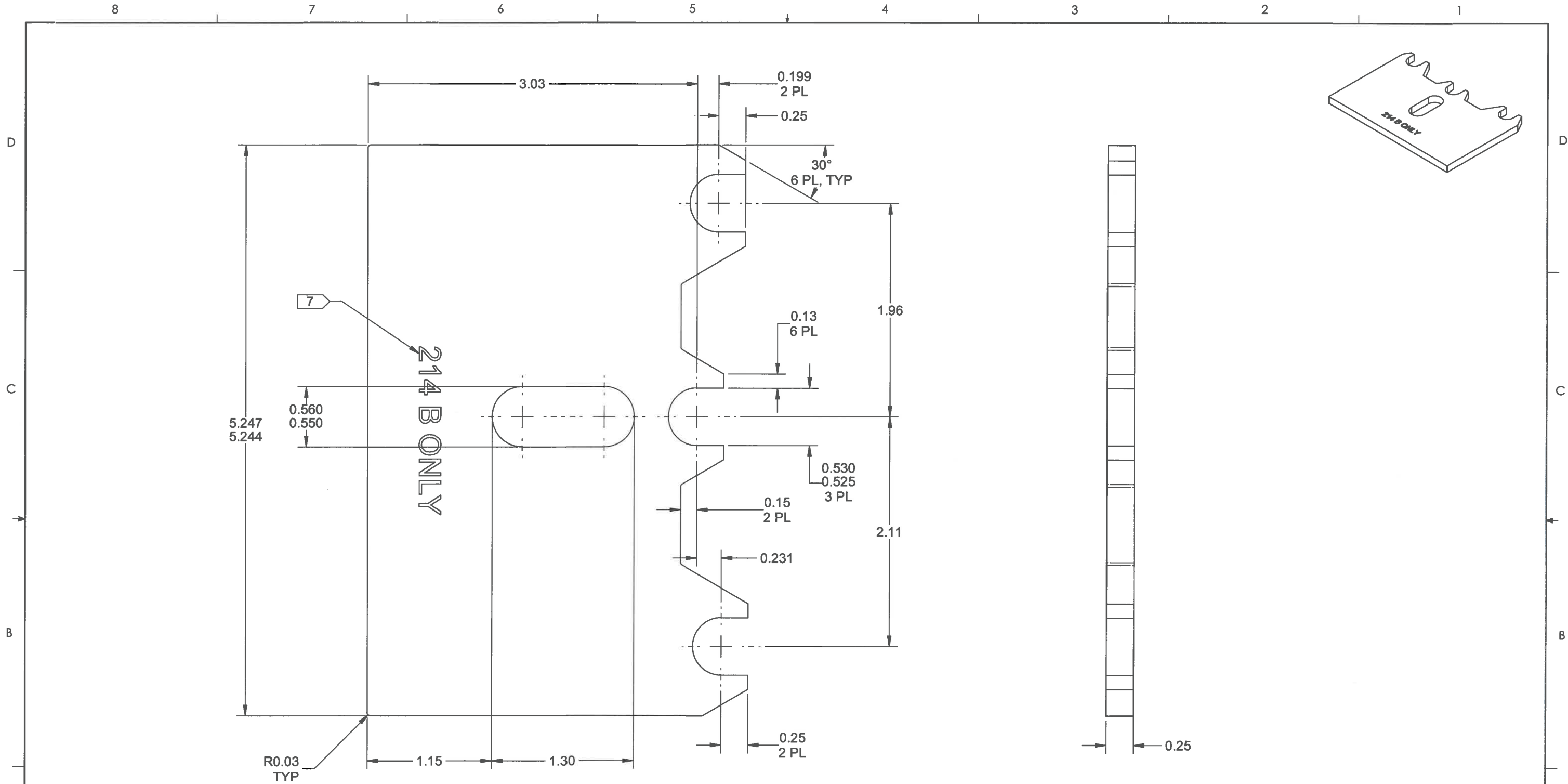
DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART # RBT102098	REV. A SHEET 2 OF 7
MFG. APPR.	DP	TITLE RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY	SCALE NTS
APPROVED			
DATE			
8/2/2018			

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NOTES:  
1) MATERIAL: 7075-T6 / 6061-T6  
2) HEAT TREAT: N/A  
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: 0.005" TO 0.010"  
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N APROXIMATELY AS SHOWN  
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER RBT102098-2REV.A.STP

DESIGN	KT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	<b>RBT102098</b>	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE <b>8/2/2018</b>		RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY	NTS
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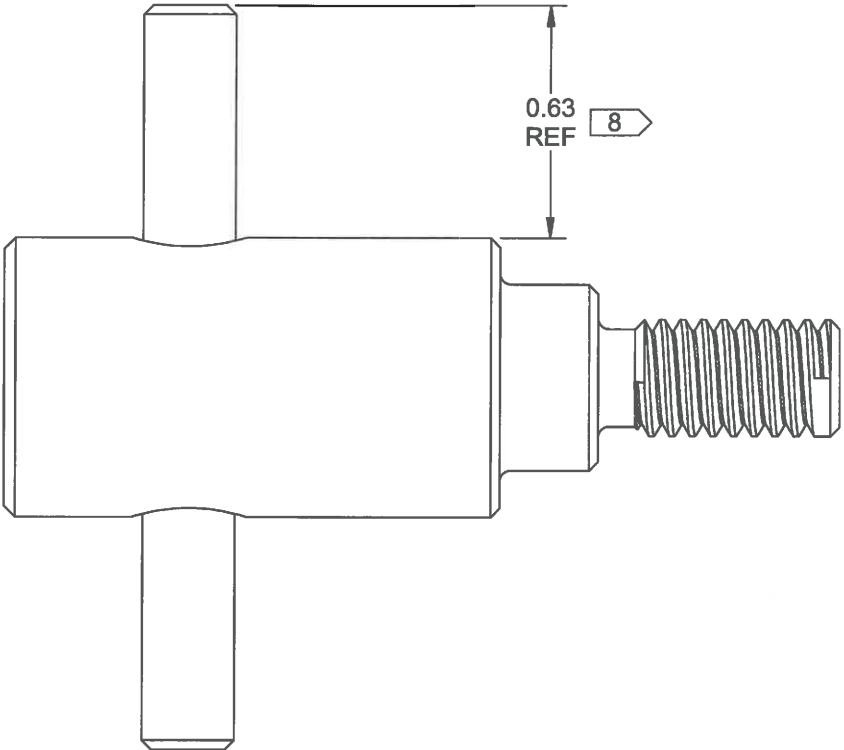
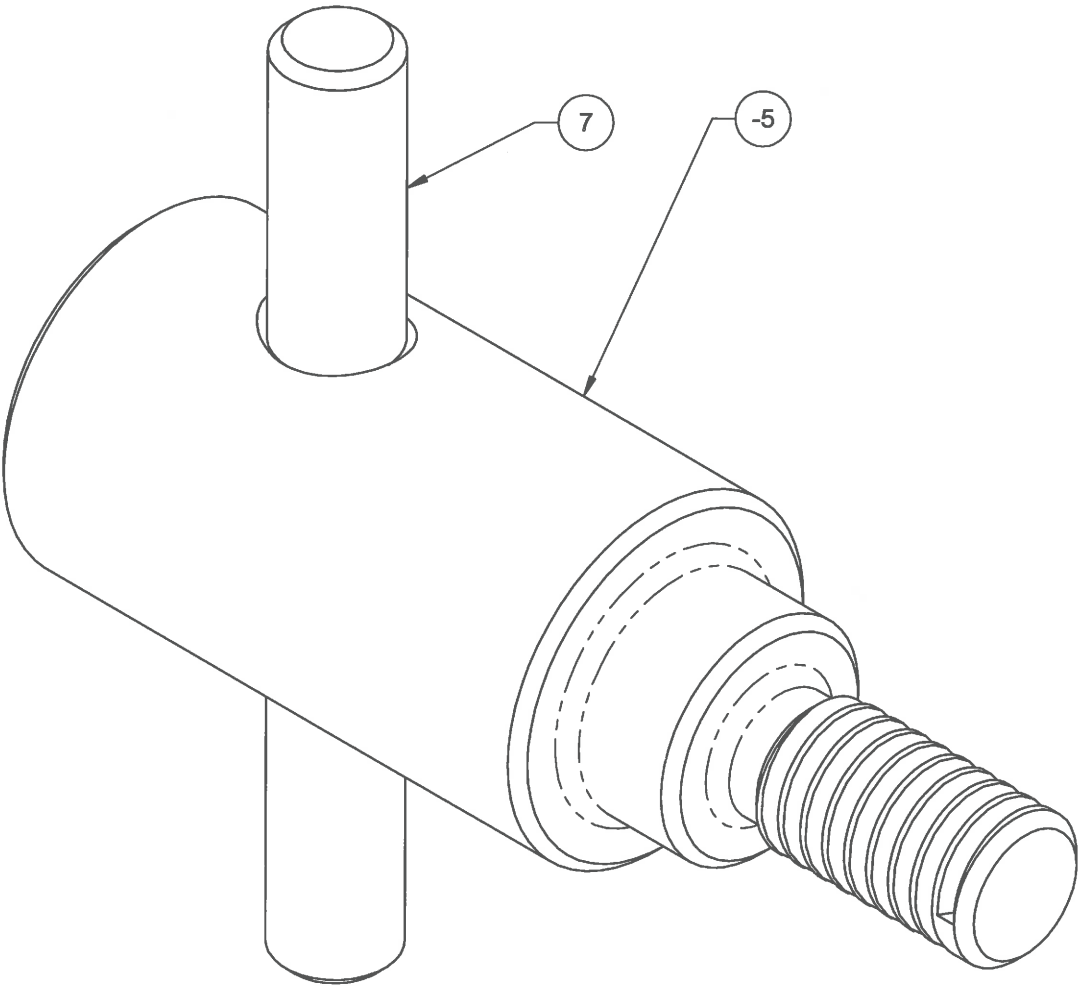


RBT102098-3 PLATE

NOTES:  
1) MATERIAL: 7075-T6 / 6061-T6  
2) HEAT TREAT: N/A  
3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: 0.005" TO 0.010"  
7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N APROXIMATELY AS SHOWN  
8) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER RBT102098-3REV.A.STP

DESIGN	KT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RBT102098	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DATE 8/2/2018		RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY	NTS
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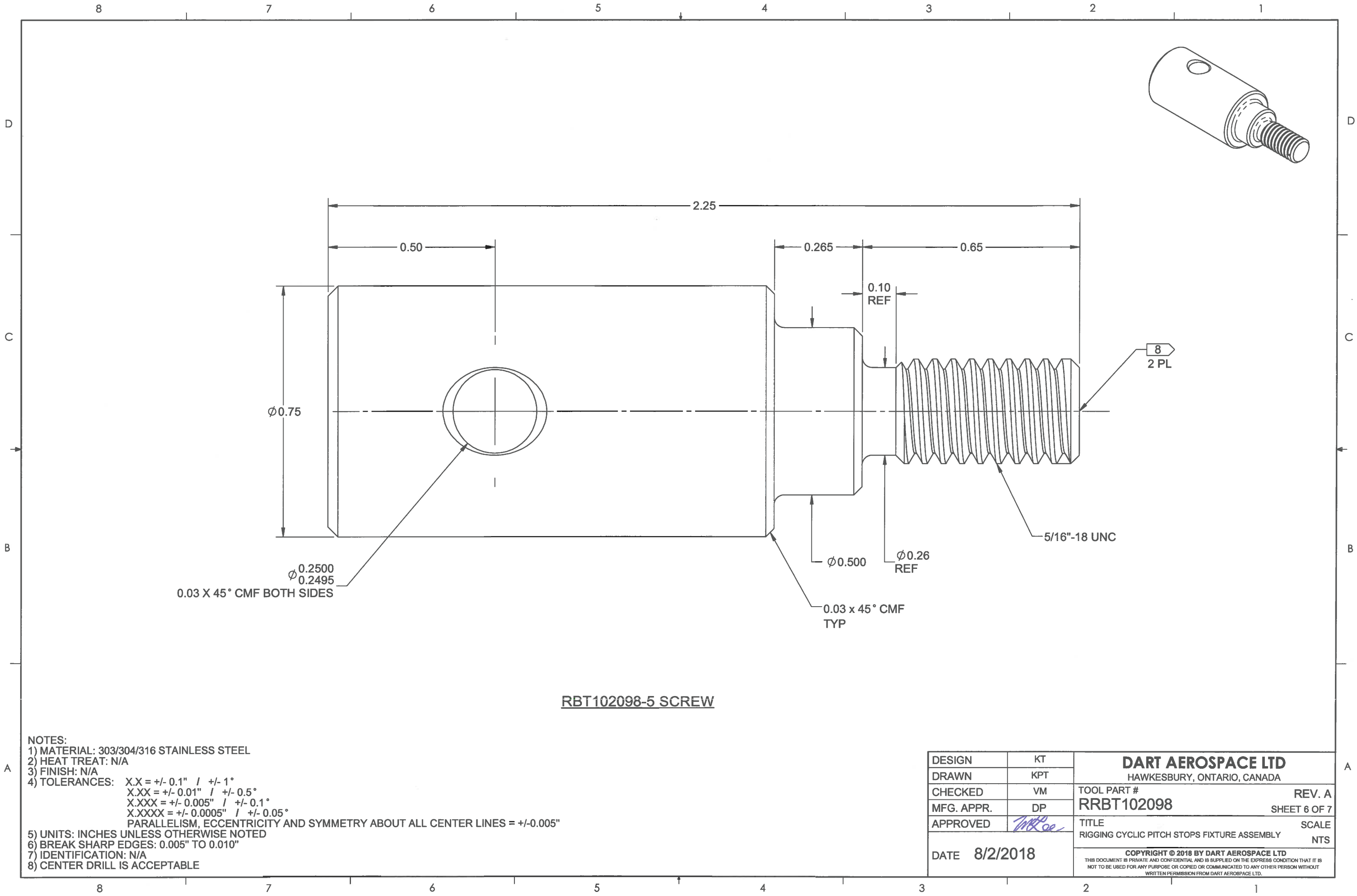
ITEM #	QTY	PART#	PART TITLE
-5	1	RBT102098-5	SCREW
7	1	McMaster#90145A549 OR EQUIV.	DOWEL PIN 1/4" DIA. X 2" LG. STAINLESS STEEL



RBT102098-4 SCREW ASSY

NOTES:  
1) MATERIAL: N/A  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: N/A  
7) IDENTIFICATION: N/A  
8) APPLY LOCTITE 620 TO MATING SURFACES THEN PRESS FIT ITEM 7 CENTERED WITH ITEM -5 AS SHOWN

DESIGN	KT	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	<b>RBT102098</b>	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE <b>8/2/2018</b>		RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY	NTS
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RBT102098-5 SCREW

NOTES:  
1) MATERIAL: 303/304/316 STAINLESS STEEL  
2) HEAT TREAT: N/A  
3) FINISH: N/A  
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°  
X.XX = +/- 0.01" / +/- 0.5°  
X.XXX = +/- 0.005" / +/- 0.1°  
X.XXXX = +/- 0.0005" / +/- 0.05°  
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"  
5) UNITS: INCHES UNLESS OTHERWISE NOTED  
6) BREAK SHARP EDGES: 0.005" TO 0.010"  
7) IDENTIFICATION: N/A  
8) CENTER DRILL IS ACCEPTABLE

DESIGN	KT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RRBT102098	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE 8/2/2018		RIGGING CYCLIC PITCH STOPS FIXTURE ASSEMBLY	NTS
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